

Work Order ID 61224

August 11, 2010 11:04:22 AM



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Item ID:	D2530	Accept		Setup	Start	
Revision ID:					Stop	
Item Name:	Handle Weldment					
Start Date:	8/11/10	Start Qty:	6.00	Cust Item ID:		
Required Date:	8/25/10	Req'd Qty:	6.00	Customer:		
Reference:						

Approvals:	Process Plan:	<u>CL</u>	Date:	<u>10/8/11</u>	Tooling:		Date:		Run	Start	
	QC:		Date:		SPC (Y/N):		Date:			Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2530	Rev B								
100	Small Fab	0.00							
	Small Fab								
Small Fab	Memo	0.00							
	1-Cut to length as per Dwg D2536								
	2-Debur								
110	QC5- Inspect part completeness to step on W/O	0.00							
	QC	0.00							
Quality Control	Memo								
120	Weld per dwg A/R S.S. rod Batch: <u>M108160</u>	0.00							
	Small Fab								
Large Fab	Memo	0.00							
Large Fab	1-Weld as per Dwg D2530 and QSI 004 using Welding Jig DT8301								

=> m.l. 10/08/23

8/10/08/23

(40)

EL 10-9-1

(X10)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 61224

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Item ID: D2530

Accept

Setup Start

Revision ID:

Stop

Item Name: Handle Weldment

Start Date: 8/11/10 Start Qty: 6.00

Cust Item ID:

Required Date: 8/25/10 Req'd Qty: 6.00

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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130

QC9- Inspect visual per QSI004- Fusion Welds

0.00



QC

Memo

0.00

Quality Control

D 10.05.01

140

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

10 10.05.01

150

Black Sandtex(Ref:4.3.5.7) per QSI005 4.3

0.00



Powdercoat

Memo

0.00

Powder Coating

M 112588
START TIME: 8:50
OVEN TEMPERATURE: 320
FINISH TIME: 9:20

BR 10-9-7 10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

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NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 61224



Parent Item: D2530



Parent Item Name: Handle Weldment

Start Date: 8/11/10

Required Date: 8/25/10

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP Rev:E Removed Purchasing 05-11-07 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M304TR0.750W.049

Purchased

No

100

f

190.8779

2.9145

18.40737



304 RD Tube .750 x .049W

Location

Loc Qty

Loc Code

MAT

163.01444

108498

0

110113

0

114482

6.6065

114852

79.08684

115010 ✓

77.3211

MAT017

27.8635

109314

9.33

110113

5.29

112800

13.2435

D2534

Manufactured

No

120

Each

30.0000

2

12



Lock Plate

Location

Loc Qty

Loc Code

WA020

30

60344

30

*
m.l
10/08/23
30.67895
EL 10-8-31
20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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NOTE: Date & initial all entries

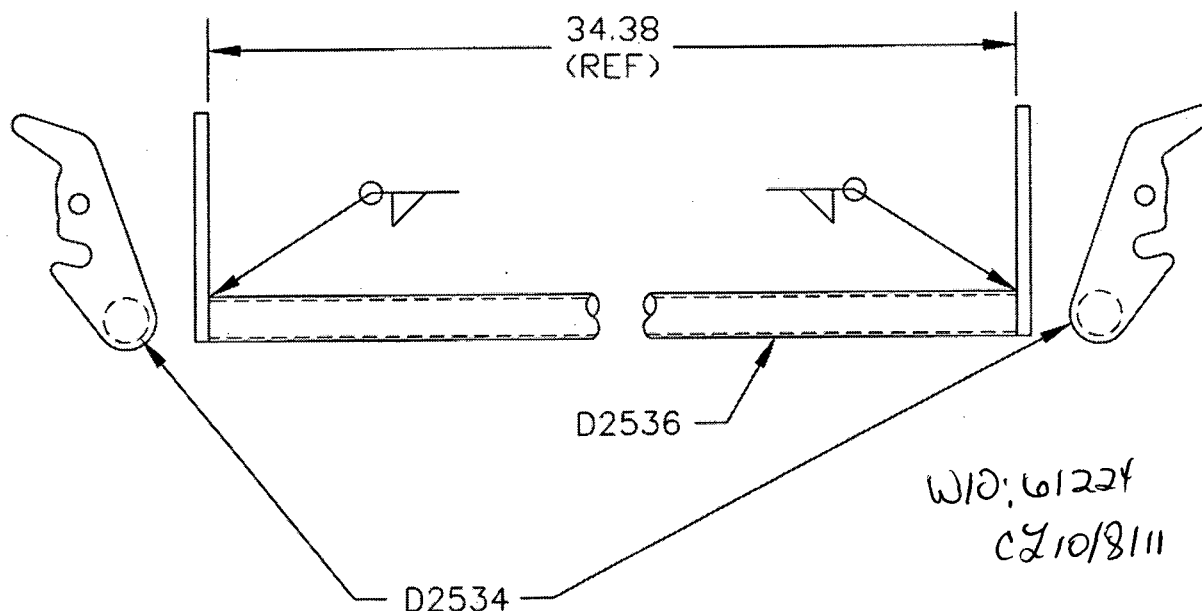
DART

DESIGN	DRAWN BY	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
B WILLIAMS	PH	DRAWING NO.	REV. B
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	D2530	SHEET 1 OF 1
DATE		TITLE	
04.12.14		HANDLE WELDMENT	
A	96.06.18	NEW ISSUE	
B	04.12.14	UPDATE NOTES AND DIMENSIONS	

RELEASED

04.12.16 *[Signature]*PART LIST -- D2530

QTY	PART NUMBER	DESCRIPTION
X	D2530	HANDLE WELDMENT
1	D2536	HANDLE
2	D2534	LOCK PLATE

D2530 HANDLE WELDMENT

- 1) WELD PER DART QSI 004
- 2) FINISH: POWDER COAT BLACK (4.3.5.7) PER DART QSI 005 4.3.
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

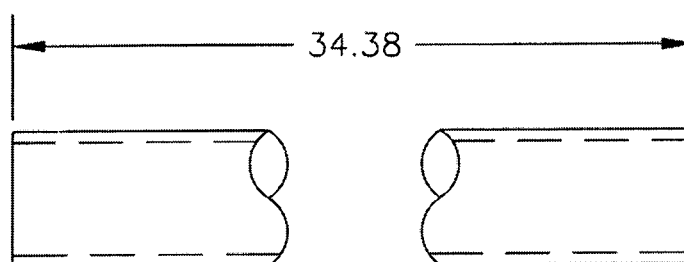


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B WILLIAMS	PH	DRAWING NO.	REV. B
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	D2536	SHEET 1 OF 1
DATE	TITLE		SCALE
04.12.14	HANDLE		NTS
A	96.05.15	NEW ISSUE	
B	04.12.14	UPDATE NOTES	

RELEASED

04.12.16 *[Signature]*

REFERENCE ONLY



D2536 HANDLE

- 1) MATERIAL: AISI 304/316 SS $\phi 0.75 \times 0.049$ WALL (REF. DART SPEC. M304TR0.750W.049)
- 2) FINISH: NONE
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED